

Date: Monday, 18/08/2008 3:45:44 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: UPPER RESTRAINT WELDMENT		
Job Number	: 41377		Part Number	: PB674300131		
Estimate Number	: 13398		Drawing Number	: B6743001 P.41/ P.43		
P.O. Number	:		Project Number	: N/A		
This Issue	: 18/08/2008 S.O. No. :		Drawing Revision	: B1		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 18/09/2008 Qty: 8 Um: Each		
Previous Run	: 40064					
Written By	:					
Checked & Approved By	: <u>DD 08.8.18</u>					
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet  
		Comment: Qty.: 0.4557 sf(s)/Unit Total : 3.6456 sf(s) 6061-T6 .090 Sheet batch: <u>108595</u> <u>BB 8-8-21</u>
2.0	WATER JET	FLOW WATER JET  
		Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-321 Dwg Rev: <u>B1</u> <u>BB 8-8-21</u> Prog Rev: <u>B1</u> ***grain direction along 25.00" *** 2-Deburr if necessary <u>BB 8-8-21</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <u>BB 8-8-21</u>
4.0	QC8	SECOND CHECK  
		Comment: SECOND CHECK  <u>508/08/02</u> <u>BB</u>
5.0	BRAKE NC	NC BRAKE  
		Comment: NC BRAKE Bend as per Dwg B67-43001  <u>BB 28/09/09</u> <u>BB</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/08/10 10x

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



10x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-f 08/09/10

8.0 POWDER COATING

POWDER COATING



10x

M102316

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

8:50

START TIME:

320

OVEN TEMPERATURE:

9:20

FINISH TIME:

m-f

08/09/13

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Upper Pad Assembly

batch:

2998

B41505

EP 08/10/09

11.0 NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch:

M10 8473

8

12.0 MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch:

107378

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: UPPER RESTRAINT WELDMENT

Job Number: 41377

Part Number: PB674300131

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
14.0	QC5	INSPECT WORK TO CURRENT STEP 
15.0	PACKAGING 1	PACKAGING RESOURCE #1 
16.0	QC21	FINAL INSPECTION/W/O RELEASE 

**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
1- Assemble as per dwg B67-43001  
*Ep08/10/08 10*

**Comment:** INSPECT WORK TO CURRENT STEP  
*S 08/10/08 44*

**Comment:** PACKAGING RESOURCE #1  
Identify and Stock  
Location: *ST510*  
*SS 08/10/08 10*

**Comment:** FINAL INSPECTION/W/O RELEASE  
*08/10/08 JJ*

Job Completion



*MF 08-10-10*

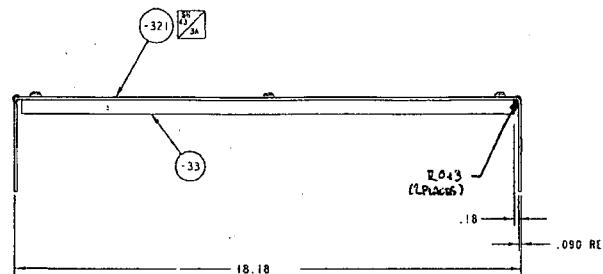
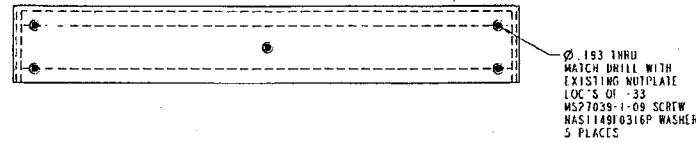
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

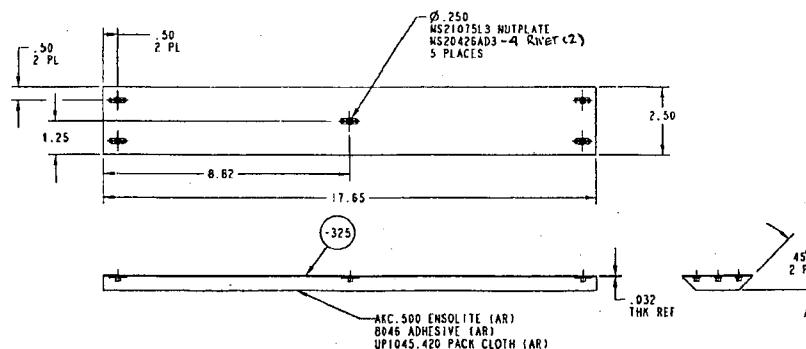
NOTE: Date & initial all entries

RELEASED  
06.01.20



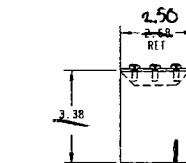
① -31 UPPER RESTRAINT WELDMENT

SCALE 0.500

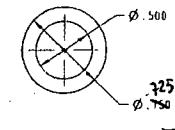


① -33 UPPER PAD ASSY

SCALE 0.500  
MATERIAL FOR .325: .032 THK 2024-T3 AL.  
00-A-250/4

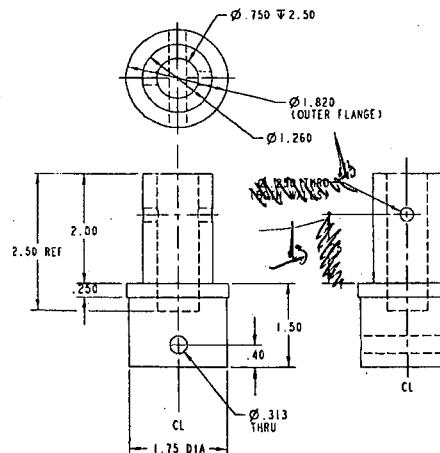


3.600 → 080900



④ -299 BUSHING

SCALE 2.000  
MAT: 304 CRES, COND A



① -305 BEARING

SCALE 1.000  
MAT: 2024-T3 AL.  
00-A-200/3

PREMIER AVIATION, INC.  
300 AVIATION Parkway, Champaign, IL 61822  
FAX: (217) 352-1010  
E-MAIL: DOSUV8  
B67-43001  
SCALE: 1:1  
DATE: 4/1/95

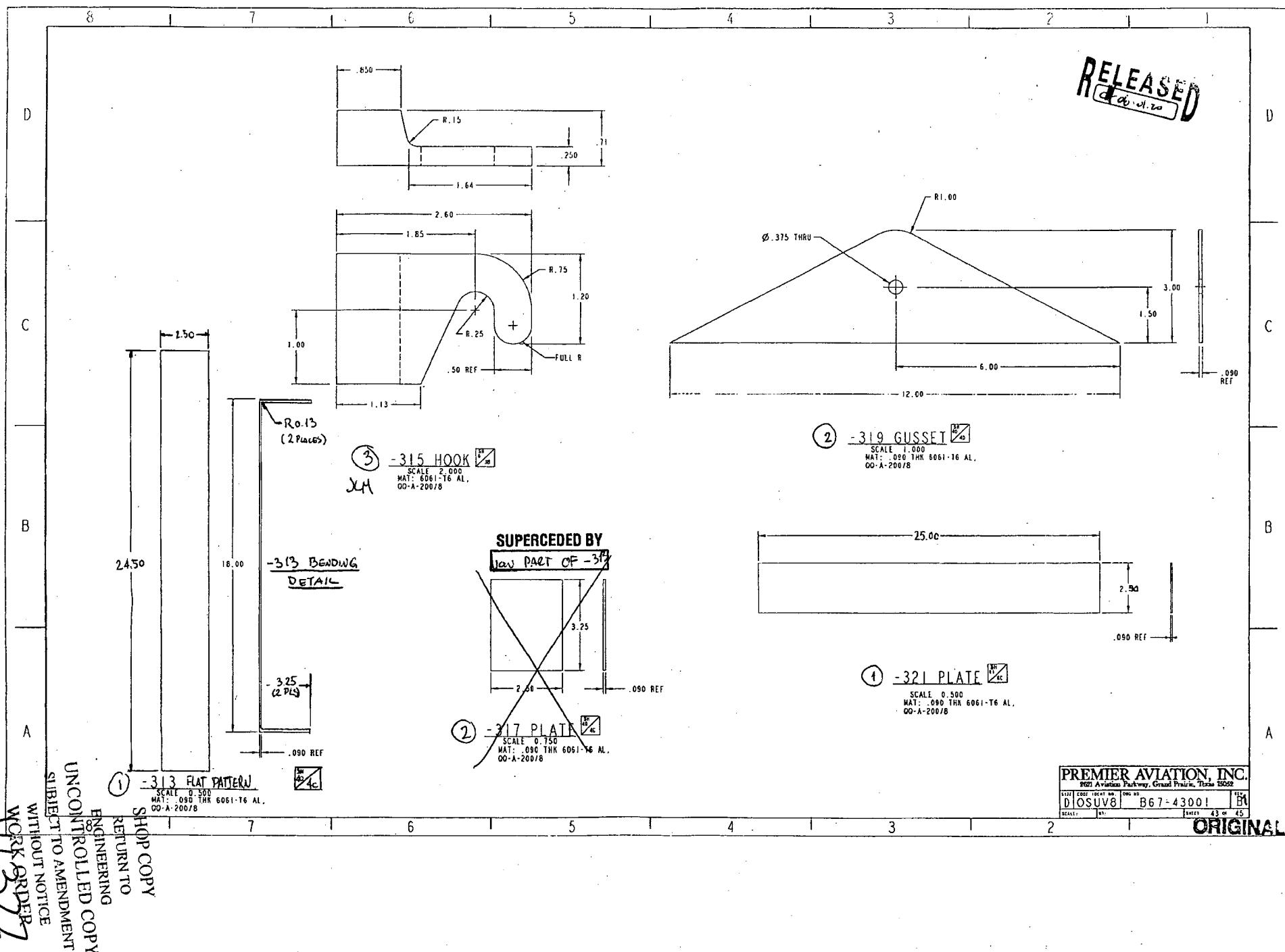
ORIGINAL

NO. 4113274  
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WITHOUT NOTICE

SHOP COPY

RETURN TO

ENGINEERING



DART AEROSPACE LTD	Work Order:	4137
Description: UPPER RESTRAINT WELDMENT	Part Number:	PB6743001-301
Inspection Dwg: 10	Rev: B	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

X First Article | Prototype

Measured by: <u>FB</u>	Audited by: <u>  </u>	Prototype Approval: <u>  </u>
Date: <u>8-8-21</u>	Date: <u>08/08/21</u>	Date: <u>  </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	8/10/2017-43001-31	KJ/JLM

H:\FORMS\Quality Assurance\approved QA\FAI revD

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